

# Work Order ID 81852

**\*81852\***

Page 1

March-19-12 4:25:42 PM

Item ID: D4407-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bar

Stop **\*NS2\***

Start Date: 19/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/20 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4407	B
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100

0.00

**\*100\***

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 66.10"

110

0.00

**\*110\***

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB082 & dwg D4407,

FOLIO REV: AA

DWG REV: B

2-Deburr as required

*ML 12/04/10* 12 *0*

*B.A 12/04/13* 12 *0*  
*ML 12/04/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81852****\*81852\***

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bar

Start Date: 19/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		12/04/14		12			
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		12-4-16		12			
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>w/a</i>  Memo	0.00 0.00				12		12-4-16	

W/O:		WORK ORDER CHANGES					
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**Work Order ID 81852****\*81852\***

Page 3

March-19-12 4:25:42 PM

Item ID: D4407-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Bar

Stop

**\*NS2\***

Start Date: 19/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

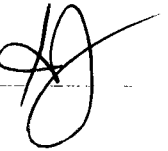
**\*150\***

QC

Memo

0.00

Quality Control

12/4/17 

R12-04-16

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**NOTE:** Date & initial all entries

# Picklist Print

March-19-12 4:25:46 PM

Page 1

Work Order ID: 81852

\*81852\*

Parent Item: D4407-1

\*D4407-1\*

Parent Item Name: Bar

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD  
12/02/13 Now on cnc JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	295.5490	5.508	69.57474			

\*M304B0 250x0 500\*

\*\*

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

295.549

120696

295.549

78.5 OK 12/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

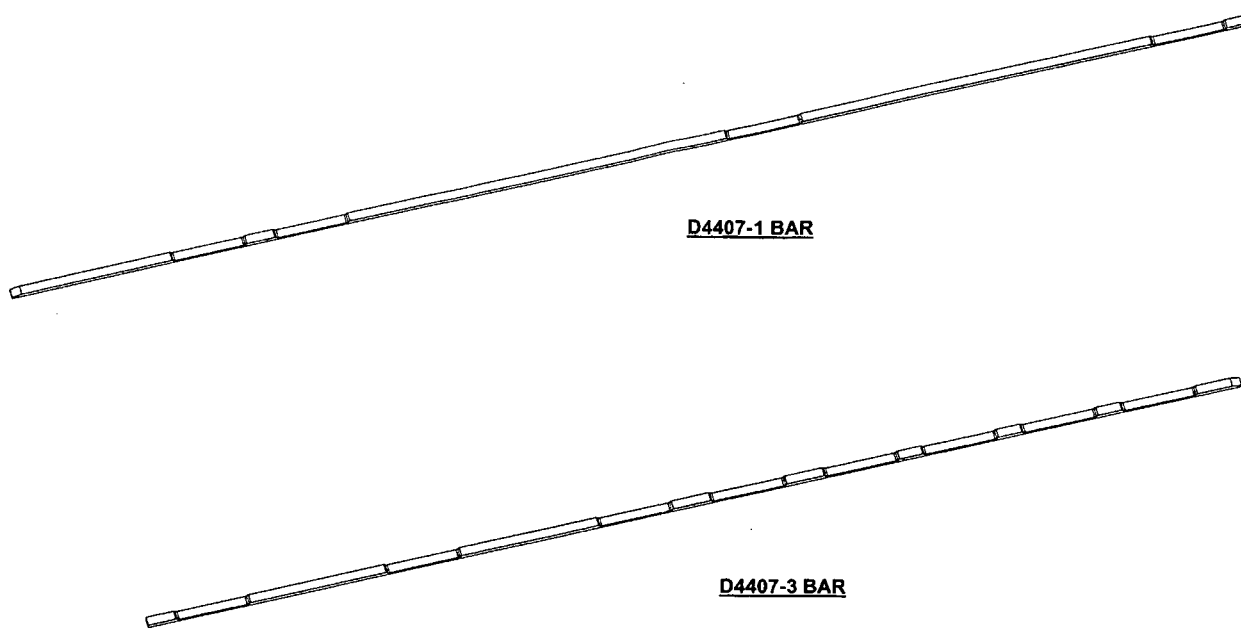
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





D4407-1 BAR

D4407-3 BAR

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 81852 MLJ  
 12/03/20

RELEASED  
 2012-02-23  
 JMT

B	REMOVE TOOLING HOLES FOR -1/-3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4407</b>	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BAR</b>	NTS
DATE	12.01.30	COPYRIGHT © 2011 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

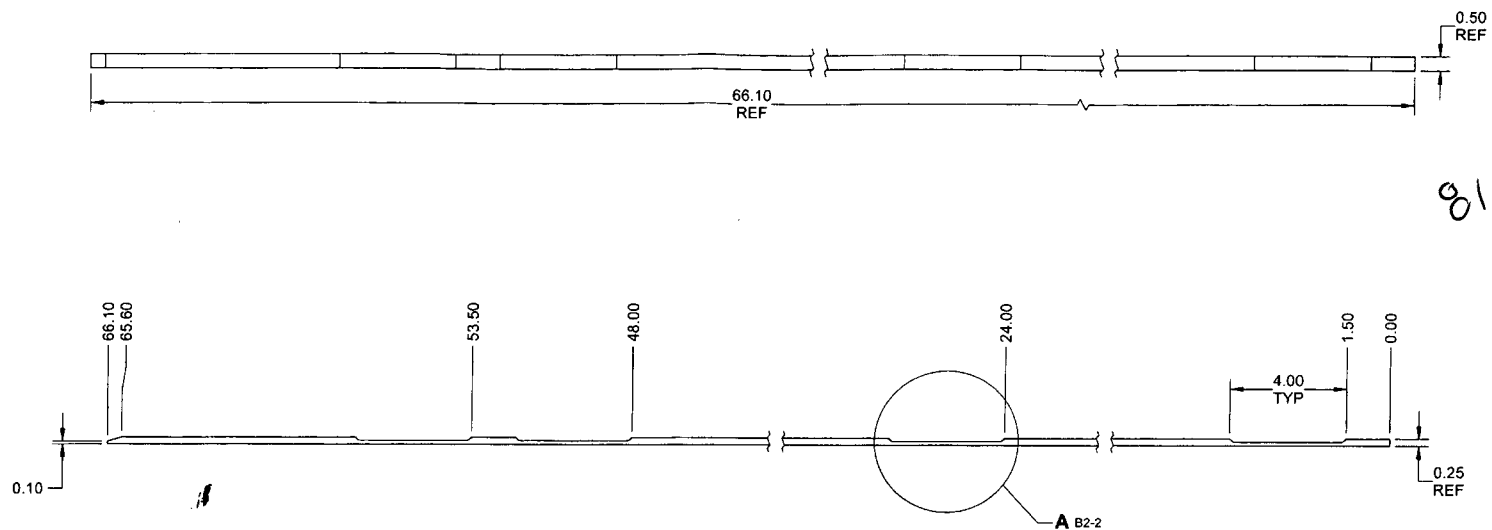
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

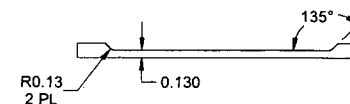
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**NOTE:** Date & initial all entries



81852

**D4407-1 BAR**



**DETAIL A** C3-2  
TYP. SCALE 2X

RELT  
2012-01-30

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR  
PER ASTM A276 OR ASTM 240  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4407	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

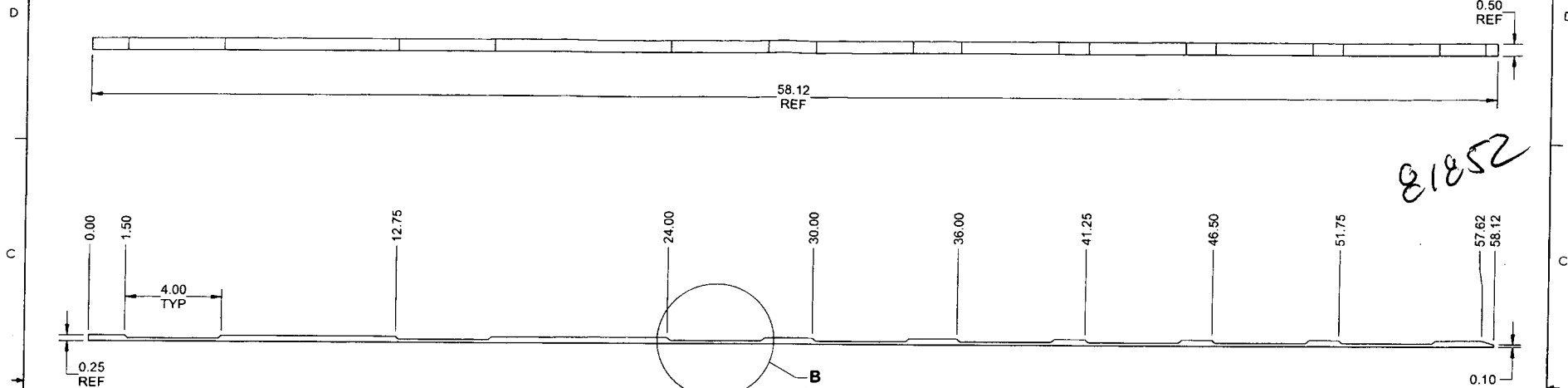
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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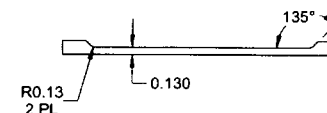
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



81852

D4407-3 BAR







DETAIL B C5-3  
TYP. SCALE 2X

RELEASED  
2012-02-23  
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR  
PER ASTM A276 OR ASTM 240  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 1.56 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4407	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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